

CLAIMS

1. A method for manufacturing a resin molded article made of an acrylonitrile-butadiene-styrene copolymer, or a polymer alloy or polymer blend containing said acrylonitrile-butadiene-styrene copolymer, comprising; the preparation of a mold whose cavity is designed to set the shrinkage ratio of said resin molded article into a range of between 4.5/1000 and 6.6/1000, the injecting of said acrylonitrile-butadiene-styrene copolymer, or said polymer alloy or polymer blend containing said acrylonitrile-butadiene-styrene copolymer, into said mold cavity, said copolymer, or said polymer alloy or polymer blend, being melted by heating at a temperature higher than 160° C, and then the injecting of a fluid at a pressure higher than the atmospheric pressure during, or after the injection of said copolymer, or said polymer alloy or polymer blend.
2. A method for manufacturing a resin molded article made of a high impact polystyrene, which is a polymer blend of a styrene graft butadiene copolymer, and a styrenic polymer, or a polymer alloy or polymer blend containing said high impact polystyrene, comprising; the preparation of a mold whose cavity is designed to set the shrinkage ratio of said resin molded article into a range of between 4.5/1000 and 6.7/1000, the injecting of said high impact polystyrene, or said polymer alloy or polymer blend containing said high impact polystyrene, into said mold cavity, said high impact polystyrene, or said polymer alloy or polymer blend containing said high impact polystyrene, being melted by heating at a temperature higher than 160° C, and then the injecting of a fluid at a pressure higher than the atmospheric pressure during, or after the injection of said high impact polystyrene, or said polymer alloy or polymer blend containing said high impact polystyrene.
3. A method for manufacturing a resin molded article made of a modified polyphenylene ether, or a polymer alloy or polymer blend containing said modified polyphenylene ether, comprising; the preparation of a mold whose cavity is designed to set the shrinkage ratio of said resin molded article into a range of between 4.5/1000 and 6.5/1000, the injecting of said modified polyphenylene ether, or said polymer alloy or polymer blend containing said modified polyphenylene ether, into said mold cavity, said modified

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polyphenylene ether, or said polymer alloy or polymer blend containing said modified polyphenylene ether, being melted by heating at a temperature higher than 175° C, and then the injecting of a fluid at a pressure higher than the atmospheric pressure during, or after the injection of said modified polypherylene ether, or said polymer alloy or polymer blend containing said modified polyphenylene ether.

4. A method for manufacturing a resin molded article made of a polymer alloy or polymer blend containing a polycarbonic ester derived from an aromatic dihydroxy compound and polystyrenic resin, comprising; the preparation of a mold whose cavity is designed to set the shrinkage ratio of said resin molded article into a range of between 4.5/1000 and 6.5/1000, the injecting of said polymer alloy or polymer blend containing said polycarbonic ester derived from said aromatic dihydroxy compound and polystyrenic resin, said polymer alloy or polymer, blend being melted by heating at a temperature higher than 175° C, and then the injecting of a fluid at a pressure higher than the atmospheric pressure during, or after the injection of said polymer alloy or polymer blend.
5. A method for manufacturing a resin molded article in accordance with Claim 4, said styrenic resin is
 - A: A copolymer of vinyl cyanide and styrenic monomer containing a graft rubber in which a graft copolymer of vinyl cyanide and styrenic monomer containing dienic rubber and/or acrylic rubber and/or olefinic rubber is (are) compounded.
 - B: A graft copolymer of a styrenic polymer and a styrenic monomer containing a dienic rubber and/or an acrylic rubber and/or an olefinic rubber.
 - C: A copolymer of a styrenic monomer in which a graft copolymer of a dienic rubber and/or an acrylic rubber and/or definic rubber and a styrenic monomer is(are) compounded.
6. A method for manufacturing a resin molded article in accordance with Claims 1 to 5, wherein said fluid is injected into said mold cavity from the injecting nozzle of an injection molding machine.
7. A method for manufacturing a resin molded article in accordance with Claims 1 to 5, wherein said fluid is injected into said molded article by using one or more injecting needle(s) and/or injecting nozzle(s) through a sprue runner.

8. A method for manufacturing a resin molded article in accordance with Claims 1 to 5, wherein said fluid is directly injected into said molded article by using one or more injecting needle(s) and/or injecting nozzle(s).
9. A method for manufacturing a resin molded article made of an acrylonitrile-butadiene-styrene copolymer, or a polymer alloy or polymer blend containing said acrylonitrile-butadiene-styrene copolymer, comprising; the preparation of a mold whose cavity is designed to set the shrinkage ratio of said resin molded article into a range of between 5.5/1000 and 7.5/1000, and the injecting of said acrylonitrile-butadiene-styrene copolymer, or said polymer alloy or polymer blend containing said acrylonitrile-butadiene-styrene copolymer, into said mold cavity, said copolymer, or said polymer alloy or polymer blend, containing a blowing agent in an amount of less than 5% by weight, and being melted by heating at a temperature higher than 160° C.
10. A method for manufacturing a resin molded article made of a high impact polystyrene which is a polymer blend of a styrene graft butadiene copolymer and a styrenic polymer, or a polymer alloy or polymer blend containing said high impact polystyrene, comprising; the preparation of a mold whose cavity is designed to set the shrinkage ratio of said resin molded article into a range of between 5.5/1000 and 7.3/1000, and the injecting of said high impact polystyrene, or said polymer alloy or polymer blend containing said high impact polystyrene, into said mold cavity, said high impact polystyrene, or said polymer alloy or polymer blend, containing a blowing agent in an amount of less than 5% by weight, and being melted by heating at a temperature higher than 160° C.
11. A method for manufacturing a resin molded article made of a modified polyphenylene ether, or a polymer alloy or polymer blend containing said polyphenylene ether, comprising; the preparation of a mold whose cavity is designed to set the shrinkage ratio of said resin molded article into a range of between 5.5/1000 and 7.5/1000, and the injecting of said modified polyphenylene ether, or said polymer alloy or polymer blend containing said modified polyphenylene ether into said mold cavity, said modified polyphenylene ether, or said polymer alloy or polymer blend, containing a blowing agent in an amount of less than 5% by weight, and being melted by heating at a temperature higher than 175° C.

12. A method for manufacturing a resin molded article in accordance with Claims 1 to 11, wherein said resin being injection molded is a recycled resin or a mixture of a virgin resin and a recycled resin in which said recycled resin is contained in an amount of more than 1% by weight.